

Date: Wednesday, 01/04/2009 7:15:16 AM
User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 46761	
Estimate Number : 13131	
P.O. Number :	Part Number : D36873
This Issue : 01/04/2009 S.O. No. :	Drawing Number : D3687 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 45912	Material :
Written By :	Due Date : 22/04/2009 Qty: 8 Um: Each
Checked & Approved By : <u>C209/04/04</u>	
Comment : Est Rev:A New Issue 08-01-15 JLM Verified By:EC Est Rev:B Added Contion H-900 JLM Verified By:DD	

NOT (9)

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES-MACH

Sub-Contracting, Ship Material to Metcor

P/O: 8148

C209/04/01

Send M74B3937 x 4750 for Heat Treating
to Condition H-900 (To become M174PHH900B3937 x 4750)
FTU IN EXCESS OF 190 KSI
FTY IN EXCESS OF 170 KSI
Certificate Required

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O for D3687-3P P.O. 9476 C209/04/01

Machine as per Dwg D3687 Rev. B

Possible Supplier: Globus Precision

Conformity sheet required

Ship to supplier:

M174PHH900B3937X4750 B m111100 C209/04/01

3.0	M174BH900 3937X4750	17-4SS Bar 3.937x4.750 COND.H900
-----	---------------------	----------------------------------



Comment: Qty.: 0.3500 F(s)/Unit Total: 2.7997 F(s)

17-4 SS Bar 3.937 x 4.750 CONDITION H-900

Batch: m111100 C209/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 01/04/2009 7:15:16 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46761

Part Number: D36873

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D36873P

MOUNT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

MOUNT

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES-MACH

Issue P/O: 8713

LPI Per ASTM 1417 LEVEL 2

Certificate of conformaty is required

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST123

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf.
09-05-13

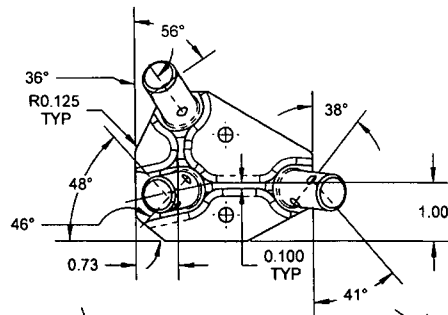
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

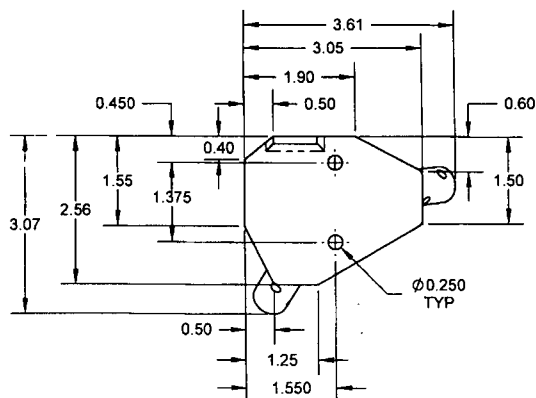
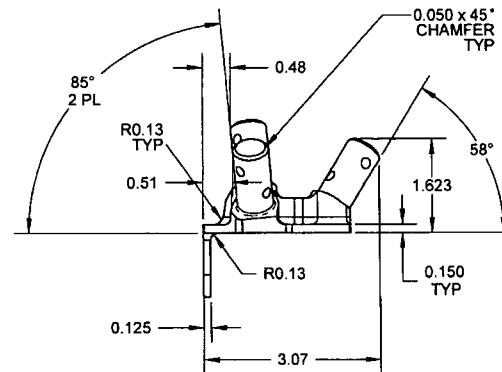
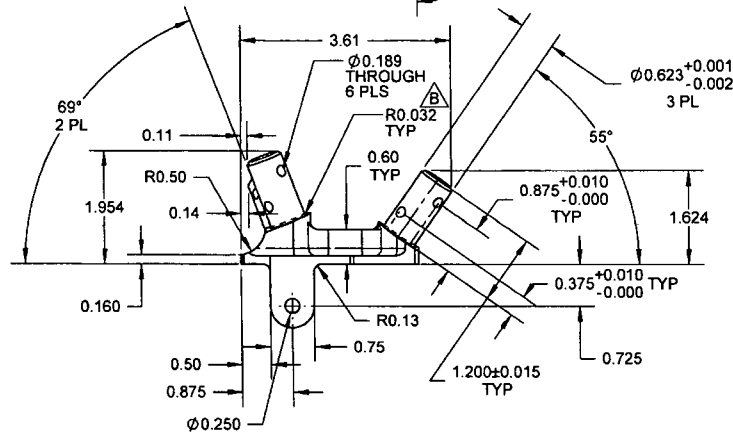
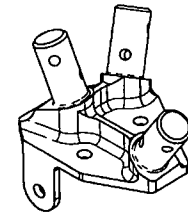
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W10:46761
C8091041101



D3687-1 MOUNT

RELEASED
08/12/15

- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

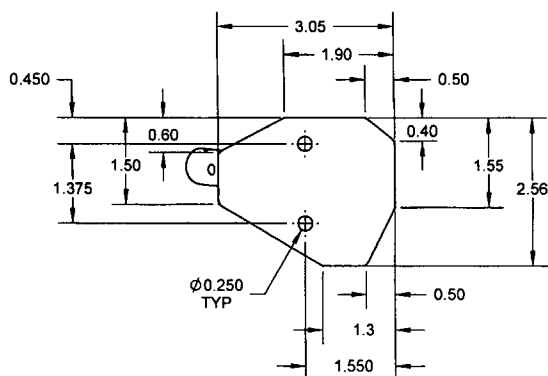
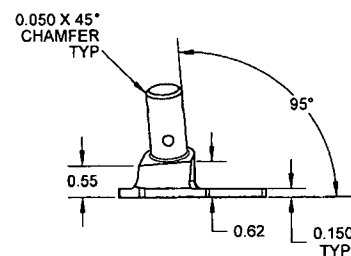
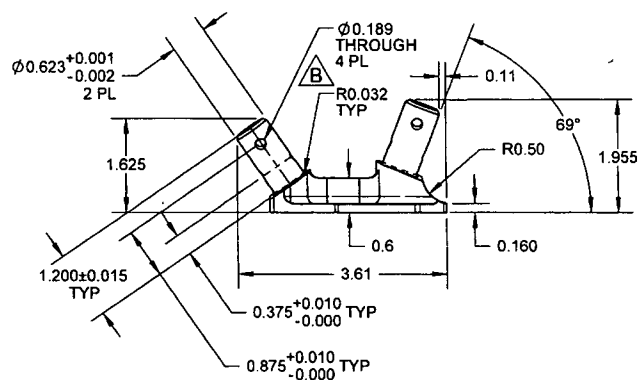
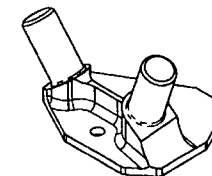
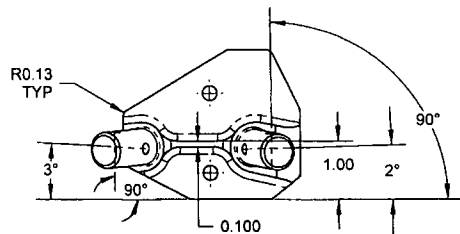
B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	4/		
MFG. APPR.	2/		
APPROVED	1/		
DE APPR.	1/		
DATE	08.11.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3687** REV. B
SHEET 1 OF 2
TITLE **MOUNT** SCALE NTS

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8 7 6 5 4 3 2 1







- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

RELEASED
08/12/15

D3687-3 MOUNT

46761

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 8
MFG. APPR.		D3687	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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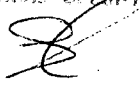
8 7 6 5 4 3 2 1



Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
4/22/2009	17547

BILL TO			SHIP TO		
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7			Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7		
P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
00008476	Net 30 Days	4/22/2009	FedEx	921	Globus
QTY	DESCRIPTION				
9	D36783P Rev. B Mount Business Number: 102122058   <p>WE CERTIFY THAT ITEMS LISTED HAVE BEEN MANUFACTURED IN ACCORDANCE WITH DRAWINGS AND PURCHASE ORDER SPECIFICATIONS</p> 				

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts

METCOR INC.
 560 BOUL. ARTHUR-SAUVÉ
 ST-EUSTACHE, QC, J7R 5A8
 Tel: 450-473-1884 / Fax: 450-491-5498

Certification

Order	Load
145892	1

Customer 215

DART AEROSPACE
 1270 ABERDEEN
 HAWKESBURY

ON K6A 1K7

Shipped To:

DART AEROSPACE
 1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number
8148		17-4PH		

PROCESSING SPECIFICATIONS

AGE HARDEN
 CONDITION H 900
 SAE AMS 2759/3 REV.E

Requirement	Specified	Tests Performed	Test Results
HARDNESS	40 - 47 HRC	1	43 - 43 HRC

Quantity	Weight	Part Number / Part Description
1	320	PIECE NIL (PAS DE CONTENANT)

Operation	Specified Temp	Specified Soak Time	Atmosphere	Carbon Potential	Q-Media Q-Temp	Furnace# Load #	Start Date	Time In	Time Out	Date Complete
1.00 CONT. INIT.	LAVAGE		si nécessaire							
2.00 PREPARING	COMPTAGE									
3.00 AGE HARDE	900 +/-10°F	1 hrs -0 +3 MIN	air			635	03-02-09	8:35	13:20	03-02-09
4.00 HARDN INS										
5.00 FINAL INSP										03-06-09

COMMENTS

APPROVED BY:		DATE: 2009-03-06
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We certify that all the information on this report is exact and in accordance with the order requirements. / Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client.

MAGNA

INDUSTRIAL

Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

1006996

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY
K6A 1K7
Contact: CHANTAL

, ON

SHIP TO:

METCOR
560 ARTHUR SAUVE
SAINT EUSTACHE
SAINT-EUSTACHE, QC
J7R 5A8

Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

Currency		Sales Person		Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS		(613) 632-5200	(613) 632-1053	7996	
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W007493	NET 30 DAYS		NIR:R-557065-1		02/05/09	02/11/09	02/13/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
312		LB	17-4 PH 3.937 X 4.7500 X 5" CUT 312 LB / 1 PC	L022189	253518 36279	312 312
skids: 1			Total Weight:		312 LB	

Received by:

St. Laurent

Date:

Signature:



LIQUID PENETRANT TEST REPORT

P- 14938

CLIENT	<u>DART Aerospace</u>	DATE	<u>MAY 1-2007</u>	PAGE	<u>1</u>	OF	<u>1</u>
ATTENTION	<u>LINDA</u>	ACUREN JOB NO.	<u>188-09-001387</u>	TIME	AM <input checked="" type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	<u>1270 ABERDEEN</u> <u>HAWKESBURY, ONT.</u> <u>K6A 1K7</u>	PO/NO.	<u>8713</u>	WORK LOCATION	<u>PLANT</u>		
PROJECT	<u>F.P.I.</u>	ACCEPTANCE STD.	<u>ASTM 1417</u>	REV./DATE	<u>2007</u>		
ITEM(S) EXAMINED	<u>MACHINED PARTS AND CROSS TUBES</u>						

JOB DESCRIPTION	PROCEDURE NO. LT-XXXX REV./DATE	TECHNIQUE NO. LT-XXXX-XXX REV./DATE
PART NO.		MATERIAL <u>STAINLESS</u> THICKNESS
SCOPE	<u>100% EXTERNAL</u> <u>EXAMINATION</u> <u>AND ALUBINE ALUMINUM X-TUBES</u>	

TEST DETAILS						
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED	
FAMILY BRAND	<u>MAGNAFLUX</u>		BLACK LIGHT S/N	<u>IPES</u>	<input checked="" type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANT	<u>2L 67</u>	MINIMUM DWELL TIME	<u>45</u>	MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER	<u>H2O</u>	MINIMUM DRY TIME	<u>>10</u>	MIN.	OTHER	<u>LABINO</u>
DEVELOPER	<u>SKD 52</u>	MINIMUM DWELL TIME	<u>10</u>	MIN.	LIGHT METER S/N	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		CAL DUE DATE	<u>FEB 2010</u>

TEST SURFACE					
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F	<input type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F	<input type="checkbox"/> > 52°C/ 125°F	

RESULTS- (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)	COMMENTS	ACCEPT	REJECT
	<u>Job # 46700 - 8 Pcs.</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
	<u># 46761 - 9 Pcs.</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
	<u># 47284 - 1 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
	<u># 47283 - 1 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
	<u># 47155 - 1 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
	<u># 47156 - 1 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
	<u># 47371 - 1 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
	<u># 46699 - 12 PC</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
<u>ALL ITEMS EXAMINED WERE FOUND ACCEPTABLE</u>			

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES		DTR # <u>E-27911</u>
CLIENT REPRESENTATIVE	<u>Jason Northch</u>	
TECHNICIAN (SIGNATURE):	<u>[Signature]</u>	REPORT REVIEWED BY:
NAME (PRINT):	<u>Mike Johnson</u>	NAME INITIALS
1 ST TECHNICIAN	CGSB LEVEL <u>II</u> SNT LEVEL	2 ND TECHNICIAN
CGSB REG. NO. <u>6060</u>	CGSB REG. NO.	